

Date Thursday, 16/08/2007 10:22:59 AM  
 User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 L WEB		
Job Number	: 33994			Part Number	: D26547	
Estimate Number	: 10722			Drawing Number	: D2654 REV E1	
P.C. Number	:			Project Number	: N/A	
This Issue	: 16/08/2007		S.O. No. :	Drawing Revision	: E1	
Prsh Rev.	: NC			Material	:	
First Issue	: / /		Type : LANDING GEAR	Due Date	: 31/08/2007	
Previous Run	: 33216			Qty:	4 Um: Each	
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM		Est Rev:E 06.04.05 Added level21	EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D26007140	EXT. "I BEAM" THICK		
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)		
Pick:	Qty	Part Number	Description	Batch
	1	D2600-7- 140	Web	<i>B-21966A ANM 07/08/17</i>
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1		
Comment:	LANDING GEAR RESOURCE 1			
	1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends			
3.0	QC5	INSPECT WORK TO CURRENT STEP		
Comment:	INSPECT WORK TO CURRENT STEP			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
Comment:	HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			
	<i>ANM 07/25/17</i>			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 L WEB

Job Number: 33994

Part Number: D26547

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>BE 07-08-17</i>
6.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>Identify and Stock Location: L.G ANM 07/08/17</i>
7.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>A 07-08-20</i>
		<i>R 07-08-20</i>

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

**DART**

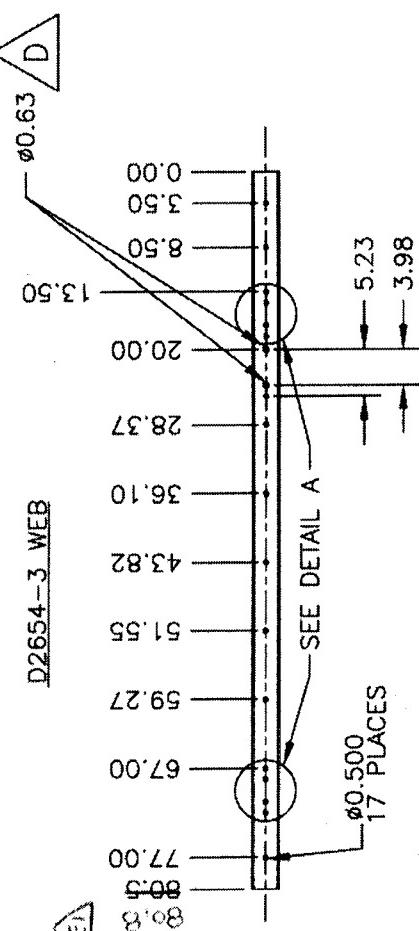
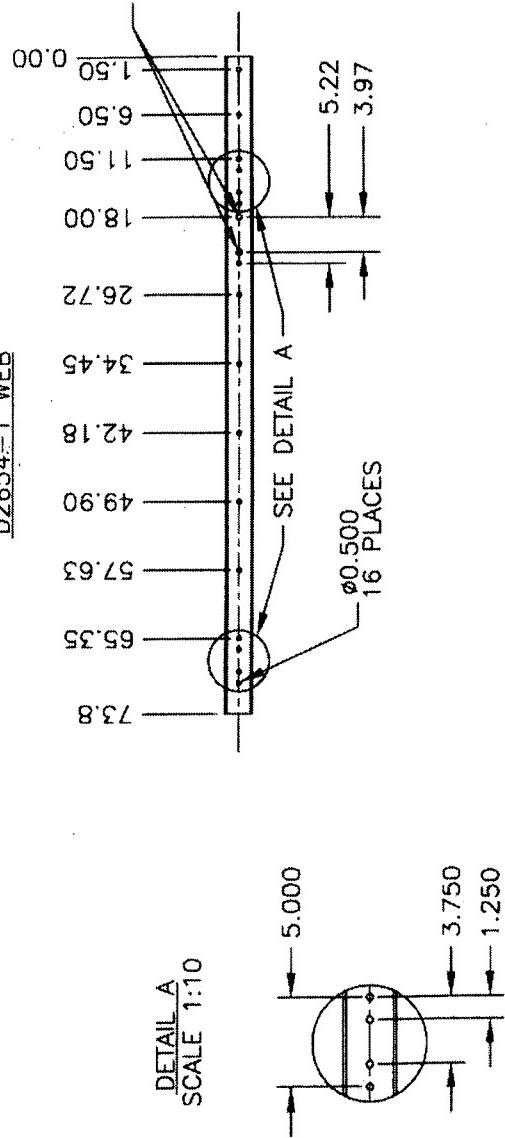


DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB SCALE 1:20
04.05.26		

**RELEASED**  
04.06.22

EI 04.05.26 PER DRAWING; 80.8 WAS 80.5

D2654-1 WEB



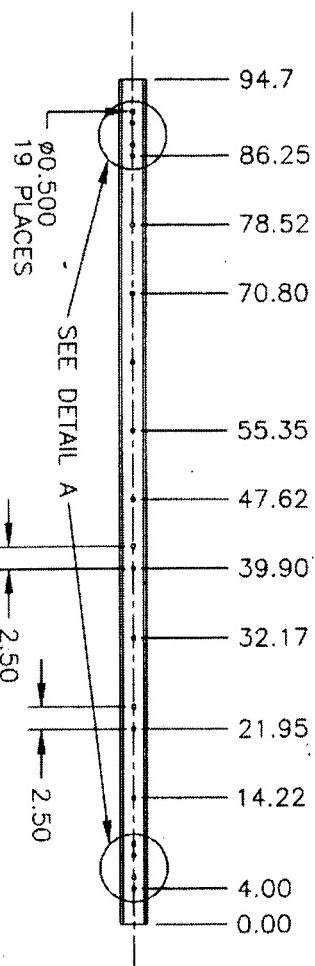
MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Ado 33994

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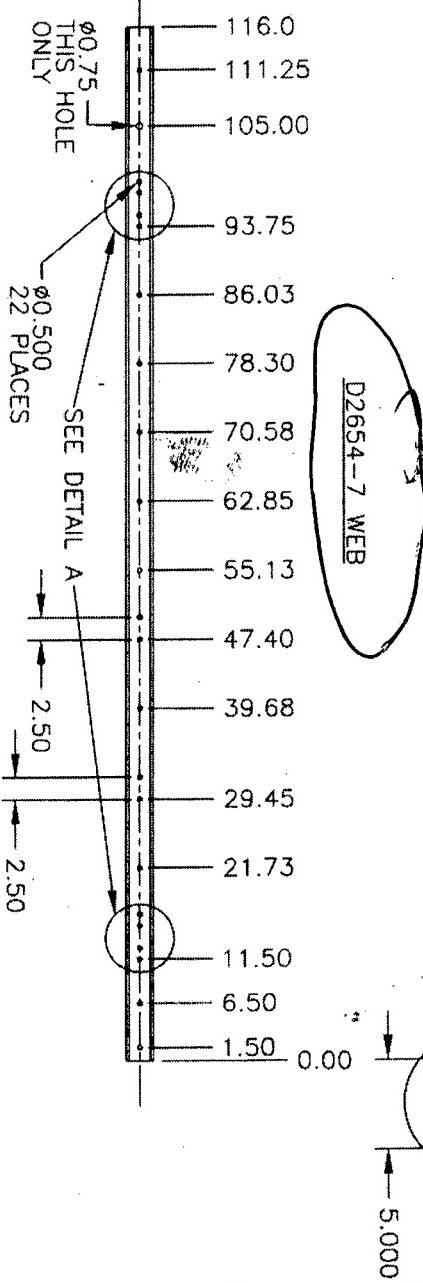
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D2654-5 WEB



DETAIL A  
SCALE 1:10  
04.05.26  
WEB  
TITLE  
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1:20

04.05.26  
WEB  
TITLE  
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SCALe  
1:20



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

04.05.26  
DART AEROSPACE USA, INC.

**DART**

DESIGN	DRAWN BY	APPROVED	TITLE	DATE	SCALe
			D2654	04.05.26	1:20